

## Claims

1. Method to process monitor and control a machine for continuous bending of long products (11) to a predetermined radius,  
**characterized in that**  
three parallel contact-free distance meters (20–22) are used and the distances are measured to the bent surface on the product (11), the actual bending radius is calculated based on the fixed distances between the meters and the measured distances, and adjustment of the machine is carried out in response to the calculated actual radius in relation the desired radius.
2. Method according to claim 1, **characterized in that** laser transmitters (20–22) are used.
3. Method according to claim 1 or 2, **characterized in that** for the calculation the bending radius between the measuring points is approximated by means of a second-degree polynomial.
4. Method according to any one of the preceding claims applied for bending of roofing sheet having raised high edges, **characterized in that** in a process step the raised edges are first rolled thinner, either against the bottom or top thereof, and then the bending is finally adjusted by means of a roll (15) that is pressed against the sheet-metal.
5. Machine for continuous bending of long products to a predetermined radius, comprising a bending device and a feeding device for feeding the long product through the bending device  
**characterized by**  
three parallel contact-free distance meters for measurement of the distances to the bent surface of the long product, a processor coupled to the distance meters for calculation of the actual bending radius and coupled to control the adjustment

of the machine in response to the relation between the calculated actual bending radius and the desired radius.